

Work Order ID 62118

Thursday, September 16, 2010 9:25:44 AM



Page 1

Item ID: PB67-43001-29

Accept



Setup Start



Revision ID:

Item Name: Blade Positioner Weldment

Stop



Start Date: 9/16/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: AMF

Date: 10-9-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100



Weld per dwg A/R Aluminum rod Batch: M112860 0.00

Large Fab

Large Fab

Memo

0.00

****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG.
MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO
WELDING****
1- ASSEMBLE AND WELD AS PER DWG

10.09.30 2 of

(P10)

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

10.09.30
PD 10.10.01

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

10.10.01

(X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-29 PAR #: _____ Fault Category: Larry Fols NCR: Yes No DQA: / Date: 10/10/08
 Resolution: re-work Disposition: re-work QA: N/C Closed: C Date: 10/10/08

NCR: 62118		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-09-30	100	The PB67-43001-337 stop plates were welded flush to the PB67-43001-313 plates; no 0.818 gap.	<u>QSI042</u> <u>L20</u>	- Trim off the -337 & grind welds smooth & flush, then the -319 gusset (to original dims). - weld new -337 stops per dwg.	<u>S</u> <u>10/10/01</u>	<u>QSI042</u> <u>L20</u>	<u>10/10/01</u>	<u>10/10/01</u>
		R.C. Lost technical details.	<u>QSI042</u> <u>L20</u>	- ensure to review dwg prior to welding. record on Job Training Log	<u>S</u> <u>10/10/01</u>	<u>QSI042</u>	<u>10/10/01</u>	<u>10/10/01</u>

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Powdercoat

Powder Coating

Operation
Description

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DK 10-10-6

2

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

10/10/11 SP 20

150



Packaging

Packaging

Identify as per dwg & Stock Location: 447

0.00

Memo

0.00

10/10/11 SP 20

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Blade Positioner Weldment

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Start Date: 9/16/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/08 JJ

MP
10-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 62118



Parent Item: PB67-43001-29



Parent Item Name: Blade Positioner Weldment

Start Date: 9/16/2010

Required Date: 9/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-27 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-313		Manufactured	No			100	Each	20.0000	1	1			



Plate

Location	Loc Qty	Loc Code
ST443A	20	
54672	20	

PB67-43001-319



Gusset

Location	Loc Qty	Loc Code
ST443A	20	
54672	20	

PB67-43001-337



Stop Plate

Location	Loc Qty	Loc Code
ST439A	13	
44967	13	

Manufactured No

Location	Loc Qty	Loc Code
ST439A	13	
44967	13	

10.09.22

Location	Loc Qty	Loc Code
ST439A	15	
44966	15	

Location	Loc Qty	Loc Code
ST439A	15	
44966	15	

10.09.22

10.09.22

10.09.22

10.09.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

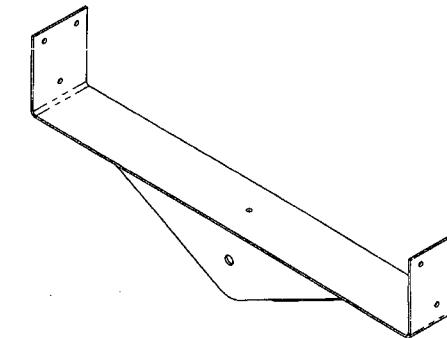
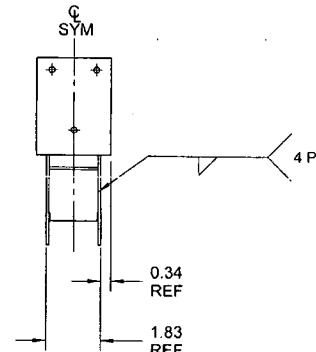
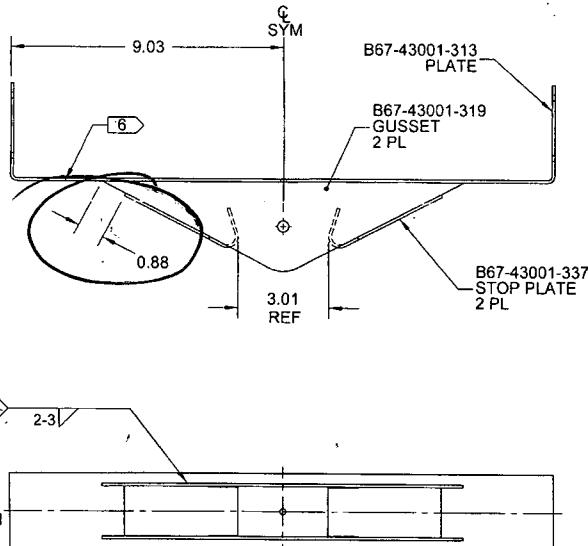
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-313	PLATE
4	2	B67-43001-319	GUSSET
5	2	B67-43001-337	STOP PLATE



B67-43001-29 BLADE POSITIONER WELDMENT

#6218

RELEASED
2009-09-24
14

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 40 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.			MB	09.06.24
REV	DESCRIPTION	BY	DATE		
DESIGN	R/W	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA			
DRAWN				DRAWING NO.	
CHECKED				B67-43001-29	REV. C
MFG. APPR.				SHEET 1 OF 1	
APPROVED				TITLE	SCALE
DE APPR.	N/A			BLADE POSITIONER WELDMENT	
DATE	09.06.24				NTS

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-29" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.01 lbs
 - 8) WELDING: PER QSI 004

8 7 6 5 4 3 2 1

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